

Work Order ID 62854

Tuesday, October 12, 2010 11:43:06 AM

Page 1

Item ID: D2221

Accept

Setup Start

Revision ID:

Item Name: 350 Basket Base

Stop

Start Date: 10/12/2010 Start Qty: 1.00

Cust Item ID:

Required Date: 10/22/2010 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

Date: 10/10/10 Tooling:

Date:

Run Start

QC:

Date: SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2221

Rev H

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1- assemble all ribs and both D2581 in DT9444 jig, weld as per dwg D2221
2- remove basket from jig and weld D3442-1 shims and D2232-3 hinges as per dwg D2221
3- tack weld mesh on basket as per dwg D2221

A/R ER316 S.S. Rod Batch: 115928

Drill holes for gas spring in D3825-041 as per DT9473

QC9- Inspect visual per QSI004- Fusion Welds

0.00

110



QC

Quality Control

Memo

0.00

BE

11-03-28

Cpl 11-03-25

1 φ

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

8 uos 128

⑦

125

Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

Hand Finishing

1 BR 11-8-08.

W/O:		WORK ORDER CHANGES					
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Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

Identify as per dwg & Stock Location: W/O

0.00 D350-607-0432/B62849



Packaging

Memo

0.00

1 0 20 11/03/29

Packaging

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/3/30

MK
11-03-29

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Picklist Print

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Page 1

Work Order ID: 62854

Parent Item: D2221

Parent Item Name: 350 Basket Base




Start Date: 10/12/2010

Required Date: 10/22/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:J 05.09.02 Added D3442-1 ☐ KJ/JLM
 IPP Rev:K 08-08-29 revG as per dwg DD verified by:EC
 IPP Rev:L 08-09-24 plug holes prior to powder coat DD verified by:EC
 IPP Rev:M 08-12-02 revH as per dwg DD verified by:EC IPP Rev:N
 10.06.29 added pressure wash DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2221-1  Rib		Manufactured	No			100	Each	14.0000	1	1			
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div> <div> <div>WA</div> <div>14</div> <div></div> </div> <div> <div>61091</div> <div>2</div> <div></div> </div> <div> <div>61424</div> <div>12</div> <div></div> </div>													
D2221-5  Rib		Manufactured	No			100	Each	12.0000	2	2			
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div> <div> <div>WA</div> <div>12</div> <div></div> </div> <div> <div>60957</div> <div>4</div> <div></div> </div> <div> <div>61753</div> <div>8</div> <div></div> </div>													
D2221-7  Rib		Manufactured	No			100	Each	6.0000	1	1			
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div> <div> <div>WA</div> <div>6</div> <div></div> </div> <div> <div>61180</div> <div>2</div> <div></div> </div> <div> <div>61754</div> <div>4</div> <div></div> </div>													

Pl 11.03.23

B64651 → ①

Pl 11.03.23

B67117 → ②

Pl 11.03.23

B65854 → ①

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Page 2

Work Order ID: 62854

Parent Item: D2221

Parent Item Name: 350 Basket Base

Start Date: 10/12/2010

Required Date: 10/22/2010

Start Qty: 1.00

Required Qty: 1.00

D2232-3 Manufactured No

100 Each

8.0000

2

2



Basket Hinge

Location

Loc Qty

Loc Code

WA

8

61182

2

61755

6



PL 11.03.23

B65418 → ②

D2235-1 Manufactured No

100 Each

16.0000

2

2



Basket Rib

Location

Loc Qty

Loc Code

WA

16

61471

6

62254

10



PL 11.03.23

B66086 → ②

D2581 Manufactured No

100 Each

51.0000

2

2



Mounting Bracket

Location

Loc Qty

Loc Code

WA

51

60470

31

61953

20



PL 11.03.23

B66500 → ②

D3442-1 Manufactured No

100 Each

16.0000

2

2



Shim

Location

Loc Qty

Loc Code

WA

16

60177

4

61181

12



PL 11.03.23

B64271 → ②

Tuesday, October 12, 2010 11:43:11 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
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Page 3

Work Order ID: 62854

Parent Item: D2221

Parent Item Name: 350 Basket Base

Start Date: 10/12/2010

Required Date: 10/22/2010

Start Qty: 1.00

Required Qty: 1.00

D3825-041

Manufactured No

100

Each

8.0000

2

2



Rib Assembly (Basket End)

Location

Loc Qty

Loc Code

WA

8

61179

2

61757

6



Pl 11.03.23

B65419 → ②

D3826-041

Manufactured No

100

Each

8.0000

2

2



Rib / Gusset Assembly

Location

Loc Qty

Loc Code

WA

8

61178

2

61676

6



Pl 11.03.23

B65420 → ②

D3827-041

Manufactured No

100

Each

9.0000

1

1



Rib Assembly (Inboard)

Location

Loc Qty

Loc Code

WA

9

61177

3

61758

6



Pl 11.03.23

B65485 → ①

D3832-1

Manufactured No

100

Each

3.0000

1

1



Mesh (Base)

Location

Loc Qty

Loc Code

WA

3

61451

3



Pl 11.03.23

B67034 → ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Page 4

Work Order ID: 62854



Parent Item: D2221



Parent Item Name: 350 Basket Base

Start Date: 10/12/2010

Required Date: 10/22/2010

Start Qty: 1.00

Required Qty: 1.00

D3833-1

Manufactured No

100

Each

14.0000

2

2



Mesh (Base End Face)

Epl 11.03.23

Location

Loc Qty

Loc Code

WA

14

61285

6

62383

8

364891 → (5)

Tuesday, October 12, 2010 11:43:11 AM

Shop Packet Print

Page 4

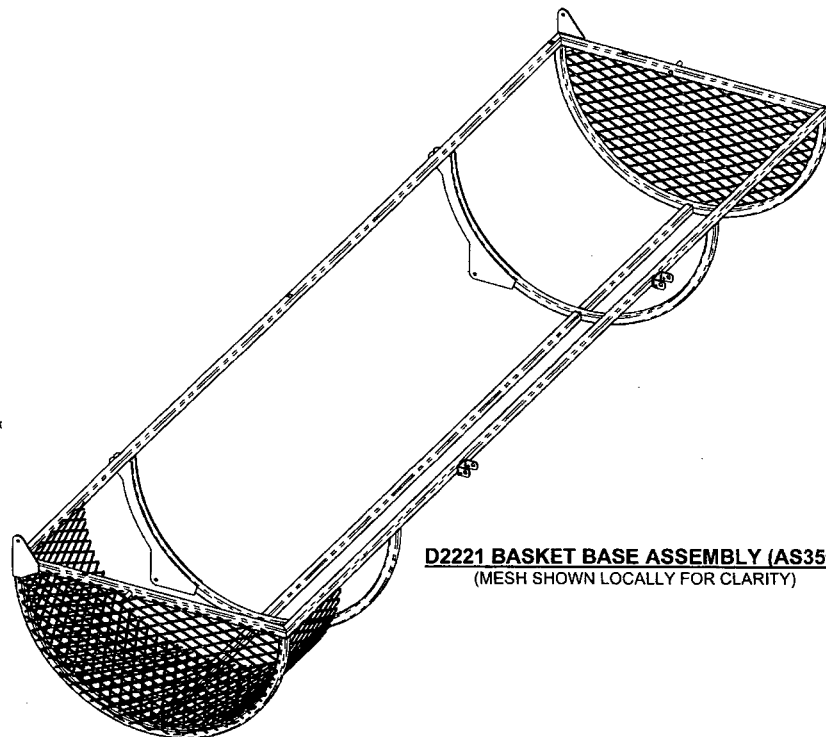
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D2221 BASKET BASE ASSEMBLY (AS350)
(MESH SHOWN LOCALLY FOR CLARITY)

SHOR COPY
RETURNED
ENCLOSURE
UNCONTROLLED COPY
SUBJECT TO MANAGEMENT
WITHOUT NOTICE
W.O. 10000
NO. 02534
08/09/18

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 8) WEIGHT: 42.00 lbs APPROX
- 9) MASK ALL HOLES PRIOR TO POWDER COATING



ITEM	QTY	P/N	DESCRIPTION
1	X	D2221	BASKET BASE ASSEMBLY (AS350)
2	1	D2221-1	RIB
3	2	D2221-5	RIB
4	1	D2221-7	RIB
5	2	D2232-3	BASKET HINGE
6	2	D2235-1	RIB
7	2	D2581	MOUNTING BRACKET
8	2	D3442-1	SHIM
9	2	D3825-041	RIB ASSY (BASKET END)
10	2	D3826-041	RIB/GUSSET ASSY
11	1	D3827-041	RIB ASSY (INBOARD)
12	2	D3833-1	MESH, BASE END FACE
13	1	D3832-1	MESH (BASE)

RELEASED
08/11/18

H	REVISED PARTS LIST AND ADDED "ITEM" COLUMN TO PARTS LIST (ZN D3-1); REVISED SECTIONS A-A, B-B AND C-C (ZN C6-3, C2-3 AND A6-3); REVISED DETAIL D (ZN B7-4); ADDED DETAIL E (ZN A6-4); ADDED SECTION F-F (ZN B2-4); ADDED DWG DETAILS FOR D2221-1/51-7 (SHEET 5); TOL REVISED TO 2 DEC PLACES (ZN D8-3 AND ZN B4-3); D3825-041 REPLACES D2221-3/D2227-3; D3826-041 REPLACES D2235-1/D2232-3; D3827-041 REPLACES D2221-1 ON INBOARD SIDE; ADDED D3832-1 AND D3833-1. REASON: SATISFY "LEAN MANUFACTURING" PROGRAM.	MB	08.09.18
G	MATERIAL FOR -1, -3, -5 & -7 WAS 0.060 WALL; TOLERANCE FOR 96.00 DIM WAS +/-0.01 AND 56.00 DIM WAS REF (ZN B5-2); 19.82 DIM WAS "HARD" DIMENSION IS NOW "REF" (ZN B4-2); NOTE 5 TRANSFERRED FROM SHT 1 TO SHT 2; SHT 2 MESH MATERIAL UPDATED; DRAWING TRANSFERRED TO "B" FORMAT	AJS	08.06.16
F	ADD SHIM UNDER HINGE; ADD HOLES FOR SPLIT LID BASKET	PH	05.06.07
E	CHANGE HINGE	CP	01.04.19
D	CHANGE LATCH	BW	96.06.21
C	SEPARATE BASKET AND LID	KH	95.11.21
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED	DES	DRAWING NO.	REV. H
MFG. APPR.		D2221	SHEET 1 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (350)	NTS
DATE	08.09.18	COPYRIGHT © 1994 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

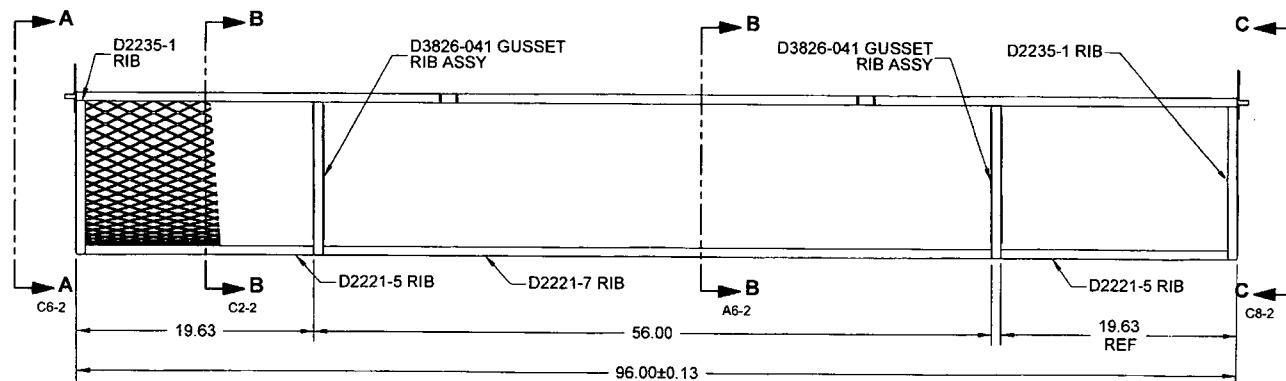
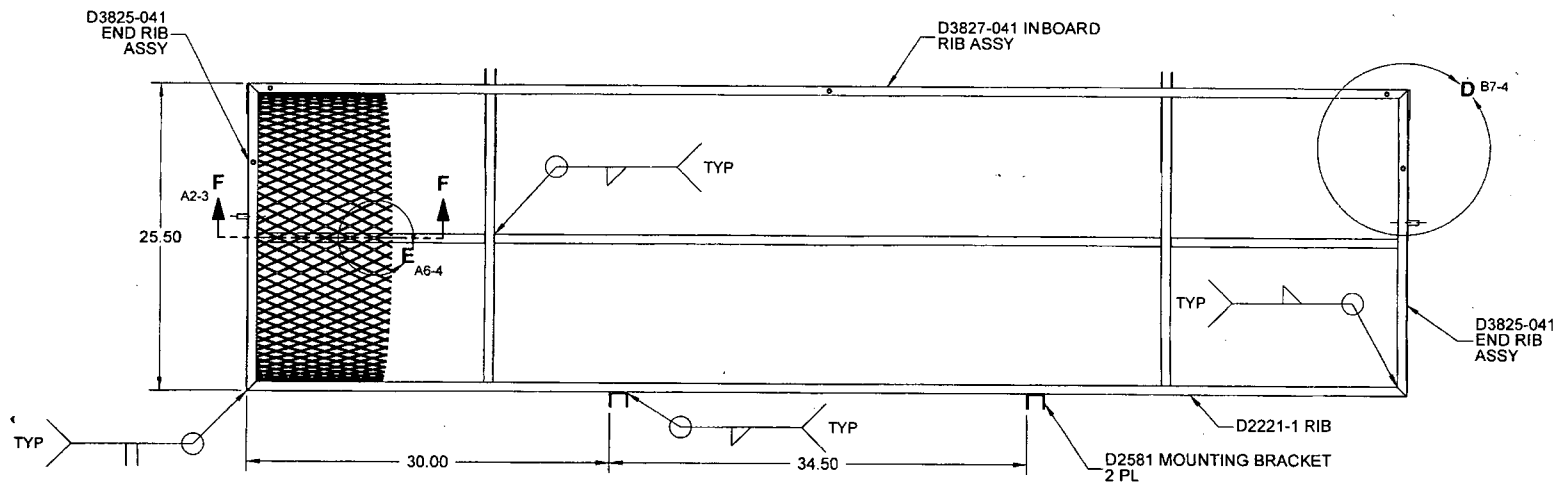
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D2221 BASKET BASE ASSEMBLY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
06/11/18

DESIGN	BW	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D2221	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (350)	NTS
DATE	08.09.18	COPYRIGHT © 1994 BY DART AEROSPACE LTD	
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W/0 62834

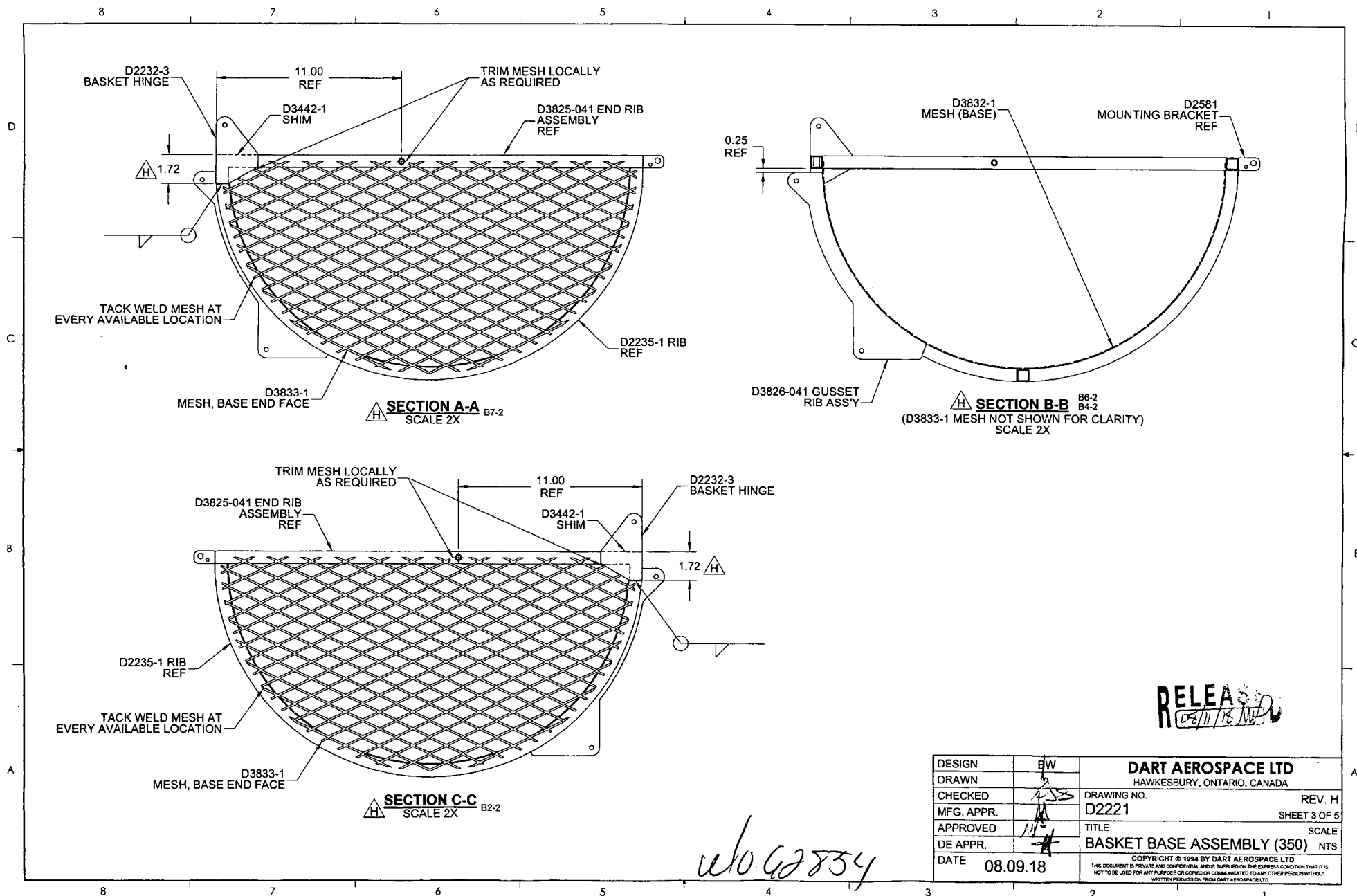
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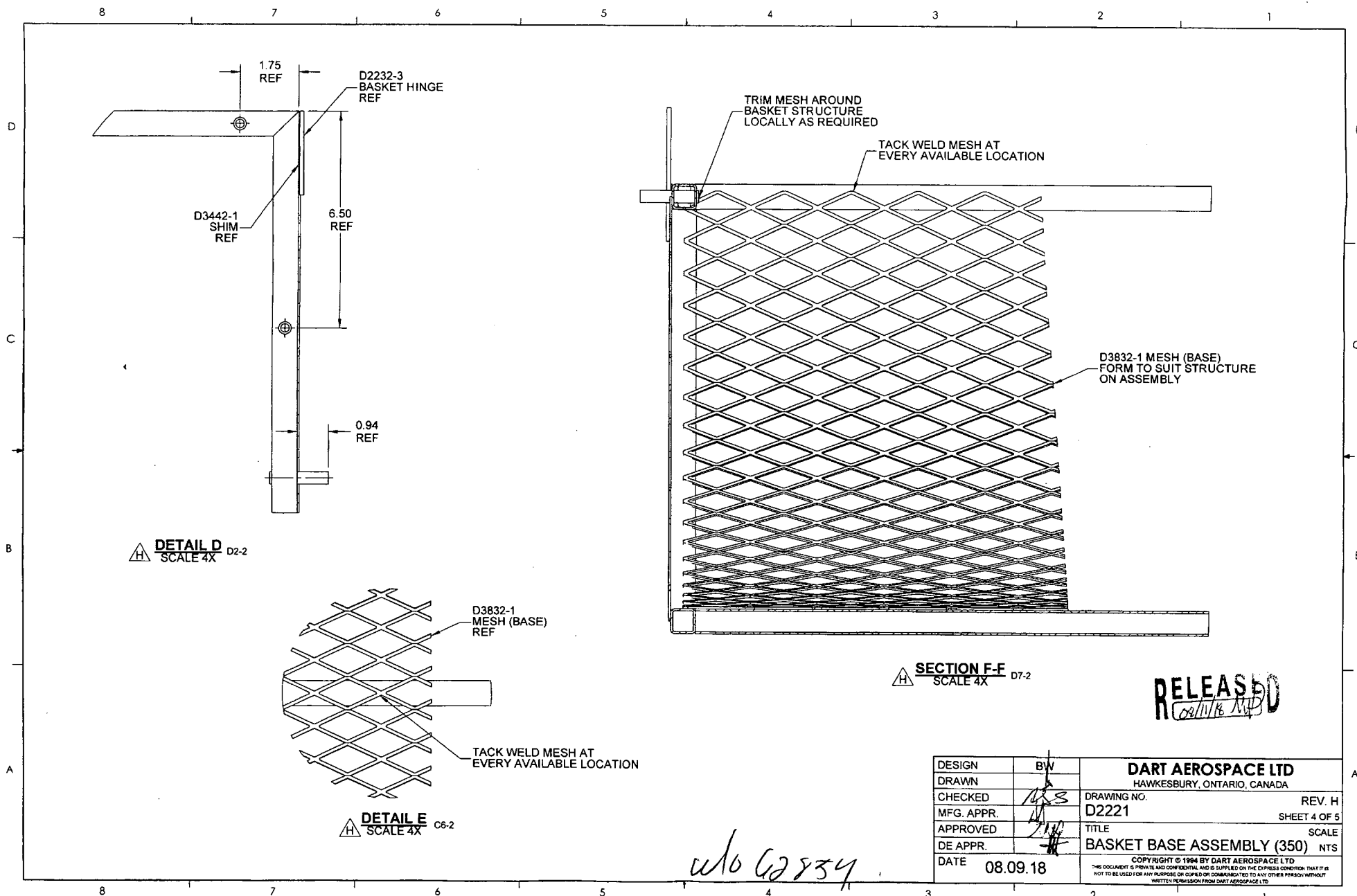
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RELEASED
08/11/16

DESIGN	BW	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>16/8</i>	DRAWING NO.	REV. H
MFG. APPR.		D2221	SHEET 4 OF 5
APPROVED	<i>2/16</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BASKET BASE ASSEMBLY (350)	NTS
DATE	08.09.18	COPYRIGHT © 1994 BY DART AEROSPACE LTD	
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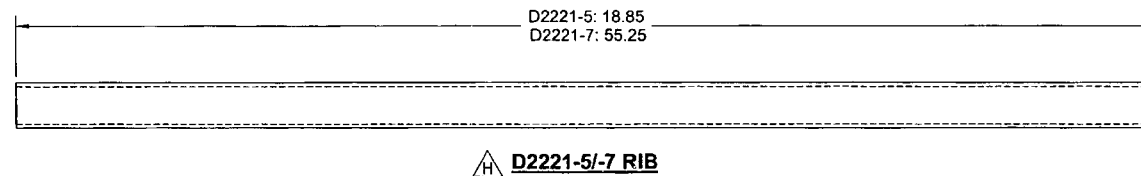
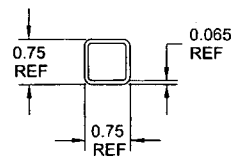
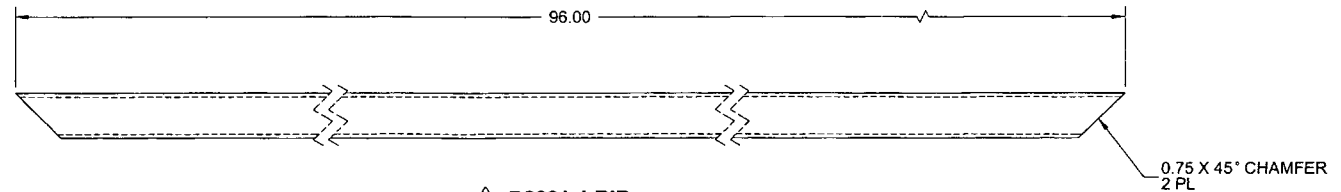
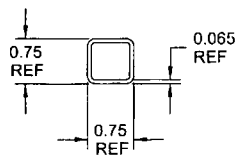
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RELEASED
08/11/18

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 8) WEIGHT: D2221 -1 = 4.57 lbs; D2221-5 = 0.90 lbs; D2221-7 2.65 = lbs

DESIGN	BW	DART AEROSPACE LTD	
DRAWN	AS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AD	DRAWING NO.	REV. H
MFG. APPR.	AD	D2221	SHEET 5 OF 5
APPROVED	AD	TITLE	SCALE
DE APPR.	AD	BASKET BASE ASSEMBLY (350)	NTS
DATE	08.09.18	<small>COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

2662854

W/O:		WORK ORDER CHANGES					
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DART SERVICE INSTRUCTION

TO AMEND DRAWING D350-607 REV. F OR SUBSEQUENT APPROVED REVISION

REF CANADIAN STC: SH94-14

FAA STC: SR00213NY

EASA STC: EASA.IM.R.S.01405

2/10
62884

THE PURPOSE OF THIS DART SERVICE INSTRUCTION (DSI), IS TO PROVIDE OPERATORS OF AS350 / 355 ROTORCRAFT EQUIPPED WITH DART D350-607-041 HELI UTILITY BASKETS WITH AN UPGRADE KIT TO REPLACE THE EXISTING LID PROP ARM WITH 2 GAS SPRINGS.

FOR OPERATORS EQUIPPED WITH D350-607-043/-045/-047 HELI UTILITY BASKETS THIS DSI WILL PROVIDE AN UPGRADE KIT TO REPLACE THE EXISTING LID PROP ARM WITH 1 GAS SPRING.

ITEM No.	QTY -141	QTY -143	QTY -145	PART NUMBER	DESCRIPTION
1	X			D350-607-141	AUTOMATIC LID OPENER INSTL (FOR USE ON -041 BASKET*)
2		X		D350-607-143	AUTOMATIC LID OPENER INSTL (FOR USE ON -043/-047 BASKET*)
3			X	D350-607-145	AUTOMATIC LID OPENER INSTL (FOR USE ON -045 BASKET*)
4	2		1	D3953-1	GAS SPRING BRACKET
5	2	1	1	D3953-3	GAS SPRING STUD (LID)
6	2	1	1	D3953-5	GAS SPRING STUD (BASE)
7	2	1	1	D3953-7	GAS SPRING SPACER
8	4	2	2	D3953-9	GAS SPRING WASHER
9	2	1	1	D3953-11	GAS SPRING SPACER
10	2		1	D3953-13	GAS SPRING SPACER
11		1		D3953-15	GAS SPRING BRACKET
12		1		D3953-17	GAS SPRING SPACER
13	2	1	1	D3969-1	GAS SPRING
14	4	2	2	AN3C11A	BOLT
15		2		AN3C15A	BOLT
18	4		2	AN3C16A	BOLT
19	4	2	2	AN310-4	CASTELLATED NUT
20	8	4	4	MS21043-3	NUT
21	4	2	2	MS24665-212	COTTER PIN
22	8	4	4	NAS1149C0332R	WASHER (OR AN960C10L)
23	4	2	2	NAS1149C0432R	WASHER (OR AN960C416L)

***NOTE:** FOR CUSTOMERS WISHING TO ORDER NEW BASKETS WITH THE LID OPENER PRE-INSTALLED USE THE FOLLOWING NUMBERS:

D350-607-041 BASKET WITH AUTOMATIC LID OPENER INSTALLED = D350-607-041A
D350-607-043 BASKET WITH AUTOMATIC LID OPENER INSTALLED= D350-607-043A
D350-607-045 BASKET WITH AUTOMATIC LID OPENER INSTALLED = D350-607-045A
D350-607-047 BASKET WITH AUTOMATIC LID OPENER INSTALLED = D350-607-047A

CANADA
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DAO # 01-O-01

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DATE: 09.11.11
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C	SHEET 1 PL, -143 INSTL, ITEM 6 QTY WAS 2, ITEM 7 WAS 0.	AJS	09.11.11
B	SHT 1 P/L ITEM 22 WAS NAS1149C0332 ITEM 23 WAS NAS1149C0432H. ALL OTHER SHEETS UPDATED ACCORDINGLY. (REASON: DRAFTING ERROR) INSTALLATIONS RENAMED.	AJS	09.11.06
A	NEW ISSUE	AJS	09.09.15
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO. REV. C	
MFG. APPR.	N/A	DSI 9473 SHEET 1 OF 8	
APPROVED	<i>[Signature]</i>	TITLE SCALE	
DE APPR.	<i>[Signature]</i>	AUTOMATIC LID OPENER INSTL NTS	
DATE	09.11.11	<small>COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

FOR D350-607-041 BASKETS, REPLACE THE EXISTING D2332-041 PROP ARM AS FOLLOWS:

62854

D350-607-141 AUTOMATIC LID OPENER INSTALLATION

NOTE: ONCE THIS MODIFICATION IS COMPLETE YOU WILL NOT BE ABLE TO RE-INSTALL THE D2332-041 PROP ARM.




- 1) REMOVE THE D2332-041 PROP ARM.
 - 2) GRIND FLUSH THE D2327-3 SPACER BUSHING ON BOTH ENDS OF THE BASKET AS SHOWN IN FIGURE 1 (IT IS PERMISSIBLE TO GRIND ALL 4 SPACERS FLUSH). TOUCH UP PAINT PER ICA-D350-607 REV. 0 SECTION 5.1 ITEM 4.
 - 3) LOCATE THE D3953-1 GAS SPRING BRACKET AS SHOWN IN FIGURE 1. TRIM STEEL MESH LOCALLY AS REQUIRED. TOUCH UP PAINT PER ICA-D350-607 REV. 0 SECTION 5.1 ITEM 4. TRANSFER MARK AND DRILL 2X Ø0.194 HOLES THRU THE BASKET LID SQUARE TUBE STRUCTURE AS SHOWN IN DETAIL A. INSTALL THE D3953-1 GAS SPRING BRACKET & D3953-13 GAS SPRING SPACER USING 2X AN3C16A BOLT, 2X NAS1149C0332R WASHER & 2X MS21043-3 NUT AS SHOWN IN VIEW E-E.
 - 4) LOCATE THE D3953-5 GAS SPRING STUD AS SHOWN IN FIGURE 1. TRIM STEEL MESH LOCALLY AS REQUIRED. TOUCH UP PAINT PER ICA-D350-607 REV. 0 SECTION 5.1 ITEM 4. TRANSFER MARK AND DRILL 2X Ø0.194 HOLES THRU THE BASKET BASE SQUARE TUBE STRUCTURE AS SHOWN IN DETAIL B. FASTEN D3953-5 IAW VIEW F-F USING 2X AN3C11A BOLT, 2X NAS1149C0332R WASHER & 2X MS21043-3 NUT.
 - 5) INSTALL 1X D3953-11 GAS SPRING SPACER ONTO THE D3953-5 STUD AS SHOWN IN VIEW F-F. INSTALL THE LARGE END OF THE D3969-1 GAS SPRING SPRING ONTO THE D3953-5 GAS SPRING STUD AND FASTEN IN PLACE USING 1X D3953-9 GAS SPRING WASHER, 1X NAS1149C0432R WASHER, 1X AN310-4 CASTELATTED NUT & 1X MS24665-212 COTTER PIN AS SHOWN IN VIEW F-F. INSTALL COTTER PIN PER MS33540 OR AC43.13 CHAPTER 7-127.
 - 6) INSERT THE D3953-3 GAS SPRING STUD INTO THE D3953-1 GAS SPRING BRACKET & INSERT THE D3953-7 GAS SPRING SPACER ONTO THE D3953-3 GAS SPRING AS SHOWN IN VIEW E-E. RAISE THE BASKET LID AND INSTALL THE ROD END OF THE D3969-1 GAS SPRING ONTO THE D3953-3 GAS SPRING STUD USING 1X D3953-9 GAS SPRING WASHER, 1X NAS1149C0432R WASHER, 1X AN310-4 CASTELATTED NUT & 1X MS24665-212 COTTER PIN AS SHOWN IN VIEW E-E. INSTALL COTTER PIN PER MS33540 OR AC43.13 CHAPTER 7-127.
- NOTE:** THE D3953-3 GAS SPRING STUD CAN BE HELD IN PLACE WITH A $\frac{9}{16}$ OPEN END SPANNER / WRENCH.
- NOTE:** WITH THE LID IN THE CLOSED POSITION THE GAS SPRING SHOULD NOT BE FULLY COMPRESSED.
- 7) REPEAT STEPS 2 THROUGH 6 AT THE OTHER END OF THE BASKET.
 - 8) TEST THE INSTALLATION. IF INSTALLED PROPERLY THE GAS SPRINGS SHOULD ASSIST THE BASKET USER IN BOTH OPENING AND CLOSING THE BASKET LID.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

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APPROVED		TITLE	SCALE
DE APPR.		AUTOMATIC LID OPENER INSTL	NTS
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FOR D350-607-043/-047 BASKETS REPLACE THE EXISTING D2332-041 PROP ARM ASSEMBLY AS FOLLOWS:

D350-607-143 AUTOMATIC LID OPENER INSTALLATION

62854

NOTE: THIS KIT MAY BE INSTALLED AT EITHER END OF THE BASKET. HOWEVER, THE PROP ARM MUST BE REMOVED IN EITHER CASE AS IT WILL INTERFERE WITH THE FUNCTION OF THE GAS SPRING.




- 1) REMOVE THE D2332-041 PROP ARM.
 - 2) GRIND FLUSH THE D2327-3 SPACER BUSHING ON THE END OF THE BASKET WHERE THE LID OPENER IS BE INSTALLED AS SHOWN IN FIGURE 2 (IT IS PERMISSIBLE TO GRIND ALL 4 SPACERS FLUSH). TOUCH UP PAINT PER ICA-D350-607 REV. 0 SECTION 5.1 ITEM 4.
 - 3) LOCATE THE D3953-15 GAS SPRING BRACKET AS SHOWN IN FIGURE 2. TRIM STEEL MESH LOCALLY AS REQUIRED. TOUCH UP PAINT PER ICA-D350-607 REV. 0 SECTION 5.1 ITEM 4. TRANSFER MARK AND DRILL 2X Ø0.194 HOLES THRU THE BASKET LID SQUARE TUBE STRUCTURE AS SHOWN IN DETAIL C. INSTALL THE D3953-15 GAS SPRING BRACKET & D3953-17 GAS SPRING SPACER USING 2X AN3C15A BOLT, 2X NAS1149C0332R WASHER & 2X MS21043-3 NUT AS SHOWN IN VIEW G-G.
 - 4) LOCATE THE D3953-5 GAS SPRING STUD AS SHOWN IN FIGURE 2. TRIM STEEL MESH LOCALLY AS REQUIRED. TOUCH UP PAINT PER ICA-D350-607 REV. 0 SECTION 5.1 ITEM 4. TRANSFER MARK AND DRILL 2X Ø0.194 HOLES THRU THE BASKET BASE SQUARE TUBE STRUCTURE AS SHOWN IN DETAIL D. INSTALL 2X AN3C11A BOLT, 2X NAS1149C0332R WASHER & 2X MS21043-3 NUT AS SHOWN IN VIEW H-H. INSTALL THE ROD END OF THE D3969-1 GAS SPRING ONTO THE D3953-3 GAS SPRING STUD USING 1X D3953-9 GAS SPRING WASHER, 1X NAS1149C0432R WASHER, 1X AN310-4 CASTELATTED NUT & 1X MS24665-212 COTTER PIN AS SHOWN IN VIEW H-H. INSTALL COTTER PIN PER MS33540 OR AC43.13 CHAPTER 7-127.
 - 5) INSERT THE D3953-3 GAS SPRING STUD INTO THE D3953-15 GAS SPRING BRACKET & INSERT THE D3953-7 GAS SPRING SPACER ONTO THE D3953-3 GAS SPRING STUD AS SHOWN IN VIEW G-G. RAISE THE BASKET LID AND INSTALL THE D3969-1 GAS SPRING ONTO THE D3953-3 GAS SPRING STUD AND FASTEN IN PLACE USING 1X D3953-9 GAS SPRING WASHER, 1X NAS1149C0432R WASHER, 1X AN310-4 CASTELATTED NUT & 1X MS24665-212 COTTER PIN AS SHOWN IN VIEW G-G. INSTALL COTTER PIN PER MS33540 OR AC43.13 CHAPTER 7-127.
- NOTE:** THE D3953-3 GAS SPRING STUD CAN BE HELD IN PLACE WITH A $\frac{9}{16}$ OPEN END SPANNER / WRENCH.
- NOTE:** WITH THE LID IN THE CLOSED POSITION THE GAS SPRING SHOULD NOT BE FULLY COMPRESSED.
- 6) TEST THE INSTALLATION. IF INSTALLED PROPERLY THE GAS SPRING SHOULD ASSIST THE BASKET USER IN BOTH OPENING AND CLOSING THE BASKET LID.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPPERD (DE # 02)

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MFG. APPR.	N/A	DSI 9473	SHEET 3 OF 8
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DE APPR.		AUTOMATIC LID OPENER INSTL	NTS
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FOR D350-607-045 BASKETS REPLACE THE EXISTING D2332-041 PROP ARM ASSEMBLY AS FOLLOWS:

D350-607-145 AUTOMATIC LID OPENER INSTALLATION

NOTE: THIS KIT MAY BE INSTALLED AT EITHER END OF THE BASKET. HOWEVER, THE PROP ARM MUST BE REMOVED IN EITHER CASE AS IT WILL INTERFERE WITH THE FUNCTION OF THE GAS SPRING.

- 1) REMOVE THE D2332-041 PROP ARM.
- 2) GRIND FLUSH THE D2327-3 SPACER BUSHING ON THE END OF THE BASKET WHERE THE LID OPENER IS BE INSTALLED AS SHOWN IN FIGURE 1 (IT IS PERMISSIBLE TO GRIND ALL 4 SPACERS FLUSH). TOUCH UP PAINT PER ICA-D350-607 REV. 0 SECTION 5.1 ITEM 4.
- 3) LOCATE THE D3953-1 GAS SPRING BRACKET AS SHOWN IN FIGURE 1. TRIM STEEL MESH LOCALLY AS REQUIRED. TOUCH UP PAINT PER ICA-D350-607 REV. 0 SECTION 5.1 ITEM 4. TRANSFER MARK AND DRILL 2X Ø0.194 HOLES THRU THE BASKET LID SQUARE TUBE STRUCTURE AS SHOWN IN DETAIL A. INSTALL THE D3953-1 GAS SPRING BRACKET & D3953-13 GAS SPRING SPACER USING 2X AN3C16A BOLT, 2X NAS1149C0332R WASHER & 2X MS21043-3 NUT AS SHOWN IN VIEW E-E.
- 4) LOCATE THE D3953-5 GAS SPRING STUD AS SHOWN IN FIGURE 1. TRIM STEEL MESH LOCALLY AS REQUIRED. TOUCH UP PAINT PER ICA-D350-607 REV. 0 SECTION 5.1 ITEM 4. TRANSFER MARK AND DRILL 2X Ø0.194 HOLES THRU THE BASKET BASE SQUARE TUBE STRUCTURE AS SHOWN IN DETAIL B. FASTEN D3953-5 IAW VIEW F-F USING 2X AN3C11A BOLT, 2X NAS1149C0332R WASHER & 2X MS21043-3 NUT.
- 5) INSTALL 1X D3953-11 GAS SPRING SPACER ONTO THE D3953-5 STUD AS SHOWN IN VIEW F-F. INSTALL THE LARGE END OF THE D3969-1 GAS SPRING SPRING ONTO THE D3953-5 GAS SPRING STUD AND FASTEN IN PLACE USING 1X D3953-9 GAS SPRING WASHER, 1X NAS1149C0432R WASHER, 1X AN310-4 CASTELATTED NUT & 1X MS24665-212 COTTER PIN AS SHOWN IN VIEW F-F. INSTALL COTTER PIN PER MS33540 OR AC43.13 CHAPTER 7-127.
- 6) INSERT THE D3953-3 GAS SPRING STUD INTO THE D3953-1 GAS SPRING BRACKET & INSERT THE D3953-7 GAS SPRING SPACER ONTO THE D3953-3 GAS SPRING AS SHOWN IN VIEW E-E. RAISE THE BASKET LID AND INSTALL THE ROD END OF THE D3969-1 GAS SPRING ONTO THE D3953-3 GAS SPRING STUD USING 1X D3953-9 GAS SPRING WASHER, 1X NAS1149C0432R WASHER, 1X AN310-4 CASTELATTED NUT & 1X MS24665-212 COTTER PIN AS SHOWN IN VIEW E-E. INSTALL COTTER PIN PER MS33540 OR AC43.13 CHAPTER 7-127.

NOTE: THE D3953-3 GAS SPRING STUD CAN BE HELD IN PLACE WITH A $\frac{9}{16}$ OPEN END SPANNER / WRENCH.

NOTE: WITH THE LID IN THE CLOSED POSITION THE GAS SPRING SHOULD NOT BE FULLY COMPRESSED.




- 7) TEST THE INSTALLATION. IF INSTALLED PROPERLY THE GAS SPRING SHOULD ASSIST THE BASKET USER IN BOTH OPENING AND CLOSING THE BASKET LID.

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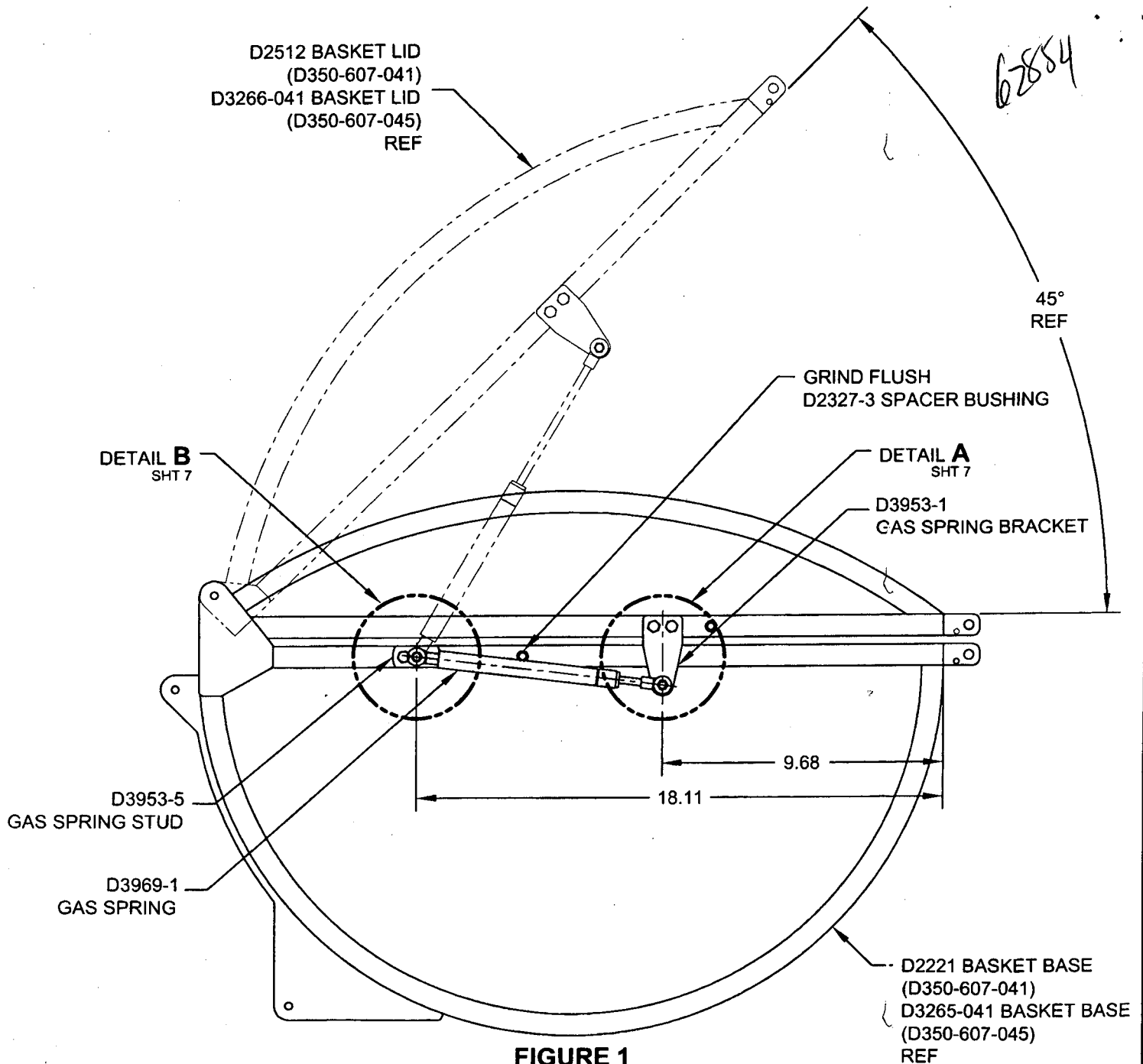


FIGURE 1

D350-607-141 AUTOMATIC LID OPENER INSTALLATION
(BOTH ENDS)

D350-607-145 AUTOMATIC LID OPENER INSTALLATION
(1 END ONLY)

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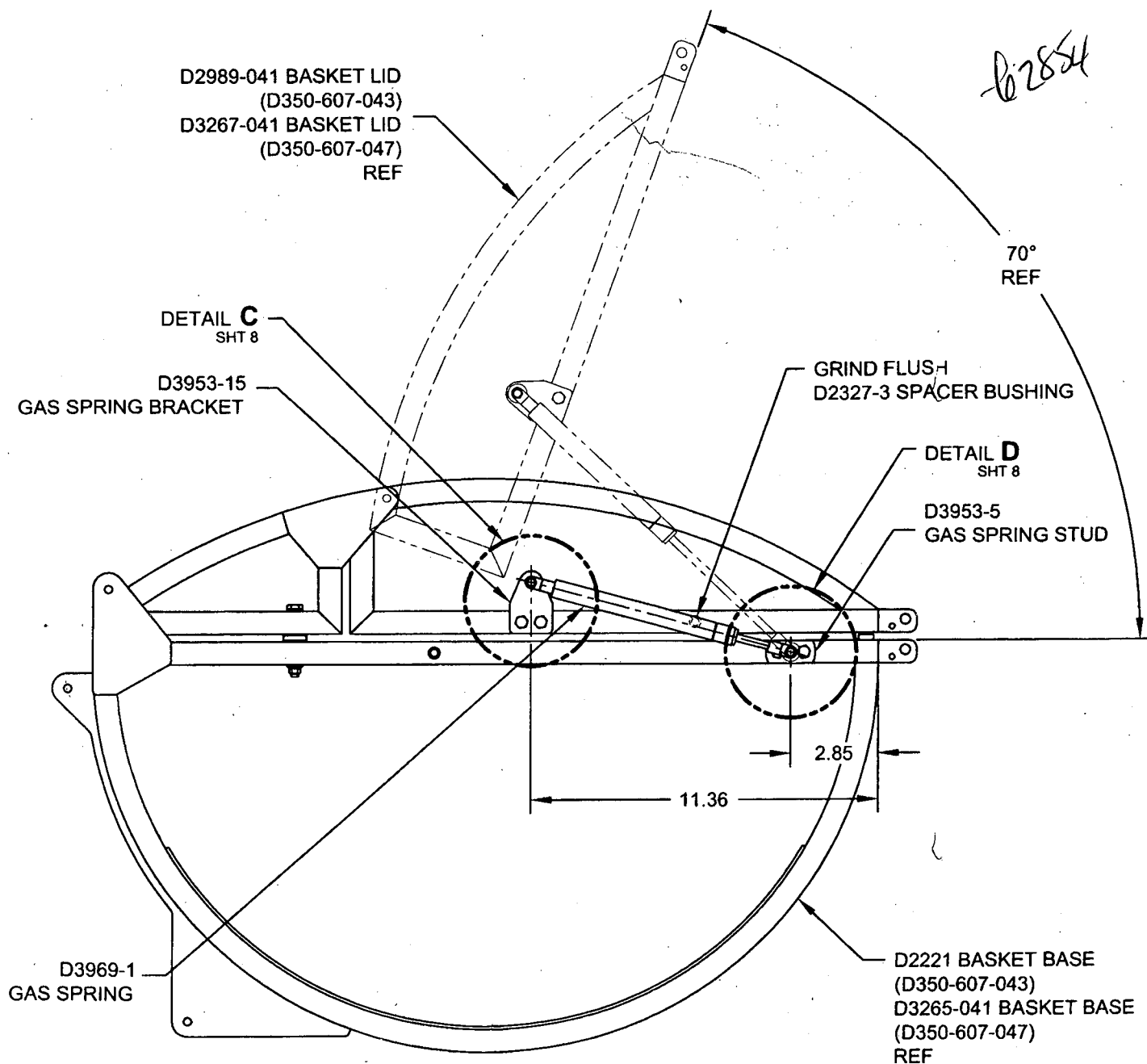


FIGURE 2

D350-607-143 AUTOMATIC LID OPENER INSTALLATION
(1 END ONLY)

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AN3C11A BOLT
NAS1149C0332R WASHER
MS21043-3 NUT
2 PL

D3953-5
GAS SPRING STUD
REF

D3953-11
GAS SPRING SPACER

D3953-9
GAS SPRING WASHER

AN310-4 CASTELLATED NUT
MS24665-212 COTTER PIN
NAS1149C0432R WASHER

VIEW F-F

AN3C16A BOLT
NAS1149C0332R WASHER
MS21043-3 NUT
2 PL

D3953-13
GAS SPRING SPACER

D3953-1
GAS SPRING BRACKET
REF

D3953-7
GAS SPRING SPACER

D3953-9
GAS SPRING WASHER

D3953-3 GAS SPRING STUD
AN310-4 CASTELLATED NUT
MS24665-212 COTTER PIN
NAS1149C0432R WASHER

VIEW E-E

D3953-5
GAS SPRING STUD
REF

TRIM MESH LOCALLY
AS REQUIRED

TRANSFER MARK AND
DRILL Ø0.194 THRU
2 PL

DETAIL B

TRIM MESH LOCALLY
AS REQUIRED

TRANSFER MARK AND
DRILL Ø0.194 THRU

D3953-1
GAS SPRING BRACKET
REF

DETAIL A

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